

Date: Thursday, 28/08/2008 1:16:39 PM  
 User: Melanie Fautoux

## Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SUPPORT ANGLE  
 Job Number : 41656 - 2  
 Estimate Number : 13281  
 P.O. Number :  
 This Issue : 28/08/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D36981  
 First Issue : 1 / 1 Type : SMALL / MED FAB Drawing Number : D3698 REV B  
 Previous Run : 41022 Drawing Revision : B  
 Material :  
 Due Date : 04/09/2008 Qty: 3 Um: 8 Each  
 Written By :  
 Checked & Approved By : MF 08-08-28  
 Comment : Est Rev:A 08-04-25 new issue DD verified by:EC  
 Est Rev:B 08-07-14 revB as per dwg DD verified by:ec

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S032 6061-T6 Sheet 0.032"



Comment: Qty.: 0.4700 sf(s)/Unit Total: 3.7598 sf(s)

6061T6 aluminium sheet .032" thick

(M6061T6S032)

Batch: B315

B 8-8-29

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3698

Dwg Rev: B

Prog Rev: B

\*\*\*\*grain direction along 1.378" \*\*\*\*

2- Deburr if necessary

B 8-8-29

11

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

808/08/29 (EC)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Bend 105 deg. angle as per Dwg D3698

808/09/02

12



# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ANGLE

Job Number: 41656

Part Number: D36981

Job Number:



Description:

Seq. #:

Machine Or Operation:

2-form curve as per dwg D3698 and verify using template DT9001

FF 08-09-03 (3)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Susoblos (3)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

JD 08-09-03 (3)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M/02316

START TIME:

3:15

OVEN TEMPERATURE:

320°

FINISH TIME:

3:45

FL 08/09/03

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JD 08-09-03 (3)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: 237

8/9/4 50

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/05

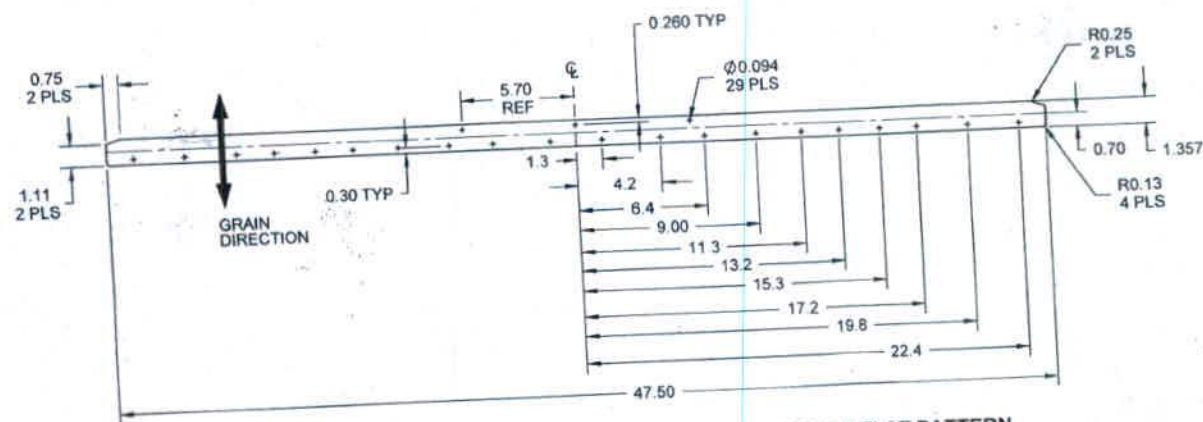
Job Completion



N 08-09-04



**D3698-1 SUPPORT ANGLE**  
(MAKE FROM D3698-1F FLAT PATTERN)



**D3698-1F FLAT PATTERN**

- NOTES:**
- 1) MATERIAL: 6061-T6 (QQ-A-250/11) SHEET 0.032 THICK (REF. DART SPEC. M6061T6S.032)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.20 lbs
  - 8) FORM AS PER TEMPLATE DT9001

REV.	B	REMOVE POWDER COAT - ZONE A,B	RF	08.06.02
REV.	A	NEW ISSUE	RF	08.05.12
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	RF	DRAWING NO.	D3698	REV. B
MFG. APPR.	RF	TITLE	SUPPORT ANGLE	SHEET 1 OF 1
APPROVED	RF	SCALE		NTS
DE APPR.	RF	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE REPRODUCED OR FOR ANY PURPOSES OR FOR ANY OTHER REASON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		
DATE	08.06.02			





